

~~Order 8921~~

~~9 OCT~~



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2563

Job Sheet 182605



Part No: D2563

Job Qty: 4 ea

Part Name: Step Weldment Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/28/18

Job Tracking No:

Due Date: 9/21/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP Rev:G 02.07.31 Re-format Location RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	9/21/18	9/21/18	0.00	0.00	Start Up Large Fab-2		
100	Large Fab	4 pcs	9/21/18	9/21/18	0.00	5.88	Large Fab 2		
110	QC	4 pcs	9/21/18	9/21/18	0.00	0.00	QC9		
120	QC	4 pcs	9/21/18	9/21/18	0.00	0.00	QC5		
130	HandFinish	4 pcs	9/21/18	9/21/18	0.00	1.07	HandFinish1		
140	QC	4 pcs	9/21/18	9/21/18	0.00	0.00	QC7		
150	Large Fab	4 pcs	9/21/18	9/21/18	0.00	5.88	Large Fab 2		
160	QC	4 pcs	9/21/18	9/21/18	0.00	0.00	QC10		
170	QC	4 pcs	9/21/18	9/21/18	0.00	0.00	QC5		
175	HandFinish	4 pcs	9/21/18	9/21/18	0.00	1.07	HandFinish2		
180	Powdercoat	4 pcs	9/21/18	9/21/18	0.00	0.67	Powdercoat1		
190	HandFinish	4 pcs	9/21/18	9/21/18	0.00	1.07	HandFinish3		
200	QC	4 pcs	9/21/18	9/21/18	0.00	0.00	QC3		
210	Packaging	4 pcs	9/21/18	9/21/18	0.00	0.00	Packaging3		
220	QC21-SA	4 Ea	9/21/18	9/21/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut D2244 to 89.70" at 34 deg as per dwg D2563 2-Deburr ends 3-Weld (1 END CAP, LUG PLATES & DESCRIPTIONS: MOUNTING ANGLE) as per dwg D2563 using DT 8343 4- Grind
150 - 1-Inspect for foreign object per QSI 024 2-Weld Remaining End cap as per Dwg D2563 using DT 8343 3-Grind
175 - Touch up Alodine as per QSI005
180 - Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 START TIME: _____

M 83983 START: 8:35 OUT: 320° FINISH: 9:05.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	4 Ea (1 ea)	90-Start up Operation	
D2561	Lug	8 Ea (2 ea)	90-Start up Operation	
D2564	Mounting Angle	8 Ea (2 ea)	90-Start up Operation	
D2673-34	End Plate	4 Ea (1 ea)	90-Start up Operation	
D2673-34	End Plate	4 Ea (1 ea)	150-Large Fab	

wing walk 5098/20.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2244-116	4	147	0
	D2561	8	16	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

150-Large Fab	D2564	8	15	0
	D2673-34	4	62	0
	D2673-34	4	62	0
Part Specifications				
Specifications could not be found.				

WORK ORDER NO

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework _____ Scrap _____ Use-as-is _____ Suspected Unapproved _____
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Date :	Step #:
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Description Work Order Deviation

**QC / QA Coordinator
Approval**

Root Cause			FAULT CATEGORY			
Environment	☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong
Design	☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions
Doc/Data	☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
Equip/Tooling	☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect
Handling/Pre	☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing
Material	☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved
Internal Transport	☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing
Tribal Knowledge	☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish
LOA	☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread
Substation	☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence
Past Expiry Date	☐	☐ Manufacturing Process				
Misidentified	☐	☐ Past Due	☐ OTHER :			